

Date: Tuesday, 12/20/2005 8:07:30 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BEARPAW KIT (13"X16")
<b>Job Number</b> : 25288	
<b>Estimate Number</b> : 10317	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : K10005
<b>This Issue</b> : 12/20/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2671 REV B1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B1
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : <u>See Comment below</u>	<b>Due Date</b> : 6/1/2006
<b>Checked &amp; Approved By</b> : <u>See Comment below</u>	<b>Qty</b> : 9 <b>Um</b> : Each
<b>Comment</b> : Est Rev:C 04.02.17 Blank size changed KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL  
 Photocopy bluefile: K10005  
 D206-559-021  
 D500-572-021  
 and create labels per PPP K10005 CHG002  
 (Bag Bluefiles separately)

DH 05-02-02.

2.0	MUHMWB10	UHMW 1" Black
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**Comment:** Qty.: 2.9444 sf(s)/Unit Total: 23.5552 sf(s)  
 blank: 13.25" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-1  
 Material: Black UHMW 1"  
 (MUHMWB10)  
 Batch: M15411 M19055

SD 05-12-28 18

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2671 Identify as D2671

3-Deburr

JL/SD 05-12-28 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 8:07:31 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (13"X16")

Job Number: 25288

Part Number: K10005

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L / SA 05.12.28 18

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

9ml 06/01/03 18

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B050

Rubber Cushion



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B050 Rubber Cushion B23172

8.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block B24872

2 D2671(ref only) Bearpaw B25288

9.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2438 Clamp B23818

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: K10005

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer B23177

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A Bolt M17566 71MCP M19085 1MCP

12.0

AN417A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-17A Bolt M15432

13.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416 Washer M6085

14.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4) M17997

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: BEARPAW KIT (13"X16")

Job Number: 25288

Part Number: K10005

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QS200M44S

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 QS200M44S Clamp M18332 8mex B19804 10mex ✓

1 Paperwork package ✓

1006/01/07 9

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 1006/01/12 9

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPk10005

Location: \_\_\_\_\_

REV C 1006/01/12 (9)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21 545 06/01/13 (9)

1006/01/13 (9)

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/13

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 25288
<b>Description:</b> Bearpaw		<b>Part Number:</b> D2671
<b>Inspection Dwg:</b> D2671 <b>Rev:</b> B1		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                         
 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060 x 45°	/			
B	5.500	+/-0.030	5.500	/		<del>TS</del>	
C	0.200	+/-0.030	0.214	/			
D	R0.250	+/-0.030	R.250	/			
E	0.625	+/-0.030	0.625	/			
F	0.250	+/-0.010	0.253	/			
G	0.950	+0.030/-0.010	0.955	/			
H	0.25 x 45°	+/-0.030	0.25 x 45°	/			
I	0.375	+/-0.010	0.375	/			
J	12.750	+/-0.030	12.750	/			
K	Ø0.260	+0.005/-0.000	0.260	/			
L	Ø0.93	+/-0.030	0.930	/			
M	0.30	+0.030/-0.000	0.308	/			
N	4.250	+/-0.030	4.250	/			
O	0.375	+/-0.030	0.377	/			
P	2.000	+/-0.030	2.000	/			
Q	4.250	+/-0.010	4.250	/			
R	9.000	+/-0.010	9.000	/			
S	15.750	+/-0.030	15.750	/		Temp	

<b>Measured by:</b> SA	<b>Audited by:</b> EP	<b>Prototype Approval:</b> N/A
<b>Date:</b> 03.12.28	<b>Date:</b> 05/12/29	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	

B1 02.12.17 | ~~Ø0.93 WAS Ø0.75~~

**DART**

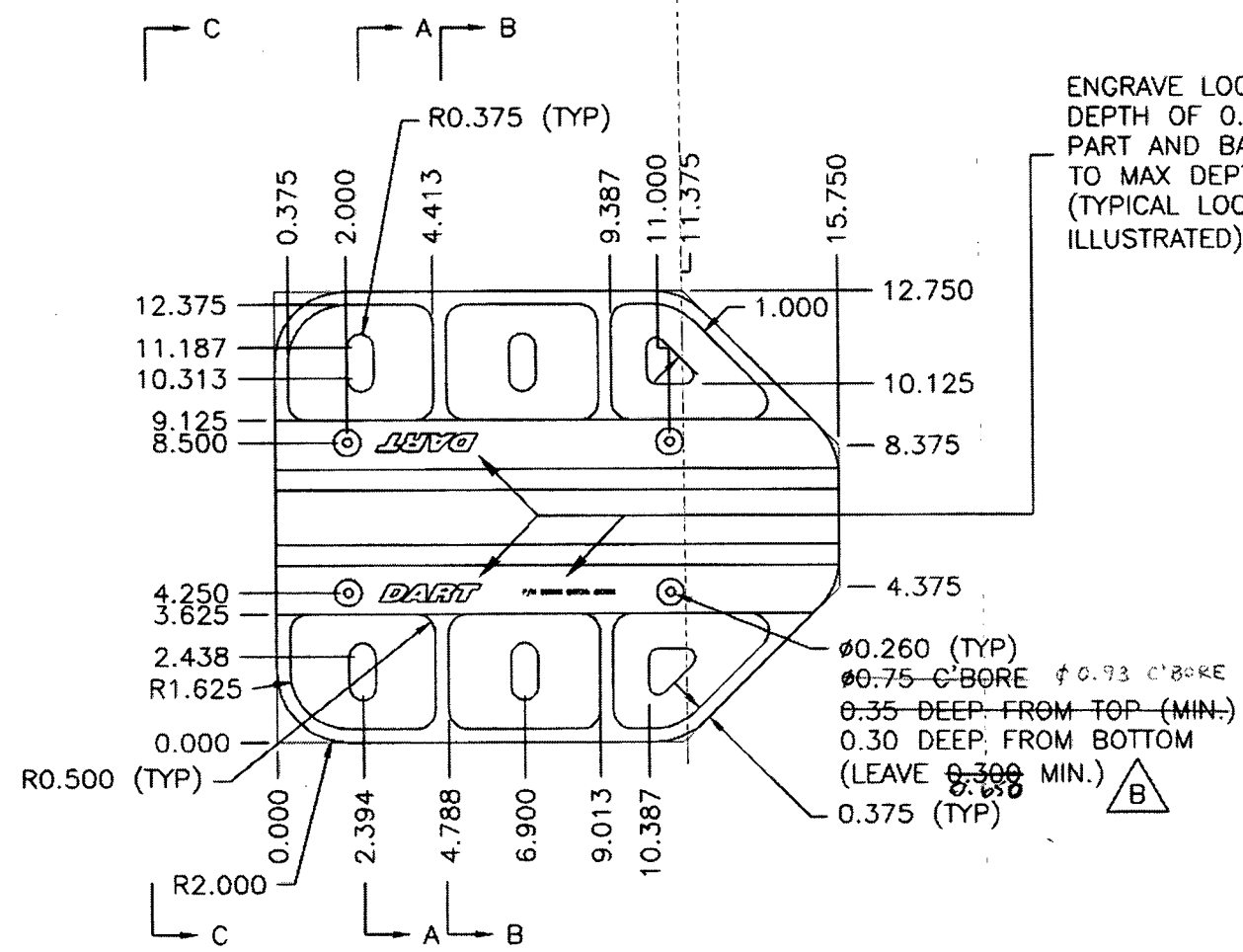


DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED <i>KE</i>	APPROVED <i>KE</i>	HAWKESBURY, ONTARIO, CANADA	
DATE 98.05.19	TITLE BEARPAW	DRAWING NO. D2671	SHEET 1 OF 2
A 97.04.08	NEW ISSUE		SCALE 1:5
B 98.05.19	CHANGE C'BORE, R1.58 WAS R1.50		

**RELEASED**  
98.06.17 KE

EFFECTIVE DEOS  
9143

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2671	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED  
98.06.17 KE

